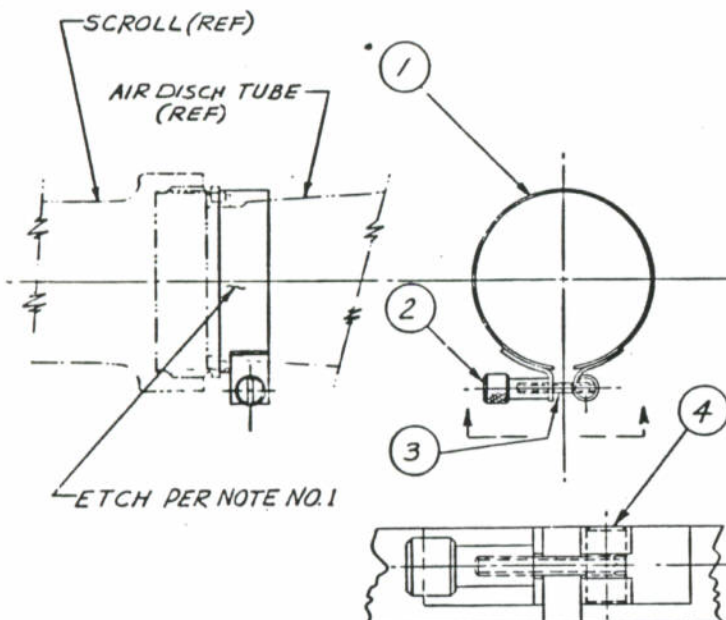


6799953

REVISIONS			
SYM.	DESCRIPTION	DATE	APPROVED
A	PARTIAL SEC. ADDED	8-3-66	ATL-3221



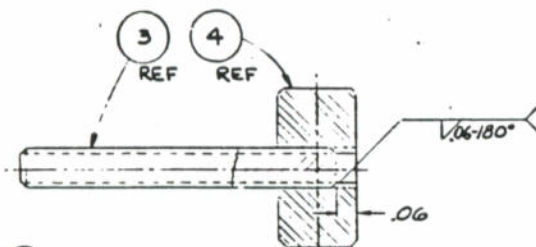
4	1	BARREL NUT			SSTL	2
3	1	STUD			SSTL	2
2	1	NUT			SSTL	2
1	1	CLAMP			STL(WELDMENT)	2
ITEM NO.	REQD.	NOMENCLATURE OR DESCRIPTION	CODE IDENT	PART OR IDENTIFYING NO.	MATERIAL OR NOTES	SH NO.

FOR PART IDENTIFICATION ITEM NUMBERS ARE EXPRESSED AS DASH NUMBERS OF THIS BASIC DRAWING, EXCEPT WHERE A NUMBER APPEARS IN THE PART OR IDENTIFYING NUMBER COLUMN

## NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8-3/16 HIGH FIGURES THE FOLLOWING:
  - a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
  - b) VENDOR NAME OR TRADEMARK.

2 X SIZE



(A) PARTIAL SECTION ITEMS 3 & 4  
4 X SIZE

SPECIAL INSPECTION  
AND TEST REQUIREMENTS

WHEN PART OR ASSEMBLY REQUIRES MAGNETIC AND/OR FLUORESCENT PENETRANT INSPECTION THERE MUST BE GOVERNMENT CERTIFIED OPERATORS AND INSPECTORS. WHEN PART OR ASSEMBLY REQUIRES WELDING OPERATORS AND EQUIPMENT MUST BE GOVERNMENT CERTIFIED. IN ADDITION FACILITIES HAVING GOVERNMENT SOURCE INSPECTION MUST HAVE GOVERNMENT APPROVAL OF X-RAY HEAT TREATMENT, ANODIZING AND PLATING EQUIPMENT WHERE APPLICABLE.

ALL PARTS OTHER THAN EXPERIMENTAL MANUFACTURED OR PROCURED TO THIS DRAWING INCLUDING REPLACEMENT SPARES ARE SUBJECT TO QUALITY CONTROL PER SPECIFICATIONS MIL-Q-985 AND USAF SPEC NOTICES THERETO, AND TO TESTING PER SPECIFICATIONS AND BULLETINS GOVERNING THE QUALIFICATION, APPROVAL AND RELIABILITY OF ALLISON PRODUCTS. MRS PROCEDURES MUST INCLUDE PARTICIPATION BY ALLISON ENGINEERING AND QUALITY CONTROL REPRESENTATIVES UNLESS OTHERWISE AUTHORIZED BY ALLISON.

USED ON ENGINE MODEL  
T63-A5

UOS BREAK SHARP EDGES .020

UNLESS OTHERWISE SPECIFIED		APPROVALS	DATE	ALLISON DIVISION	
TOL. ON ANGLES = 1°		DRAWN	MCING	GENERAL MOTORS CORPORATION	
TOL. ON 3 PLACE DECIMALS = .010		CHECKED	U.P.K.	INDIANAPOLIS, INDIANA	
TOL. ON 2 PLACE DECIMALS = 1/64		CHK. DR.	WJSEY	TITLE	
4 PLACE DECIMAL DIMENSIONS WITHOUT TOLERANCES ARE BASIC		METALLURGY		CLAMP-INSTALLATION, COMPRESSOR SCROLL TO AIR DUCT (SEAL RING)	
MAIL SEE DETS		ENGR. 1 E.G.H.		MODEL	
HEAT TREAT.		ENGR. 2 G.B.L.		CODE	
WELD OR BRAZE		ENGR. 3		SIZE DWG. No.	
SURFACE TREAT.		FINAL		73342 C 6799953	
INSPECTION		REVIEW APPROVAL		SCALE FULL	
				NOTED	
				SHEET 1 OF 2	

6799953

LAST CHG LTR  
COMPLETE UNIT

EACH ITEM PURCHASED SEPARATELY  
MUST BE STAMPED OR ETCHED WITH  
TOOL NUMBER AND DETAIL NUMBER.  
IF SUITABLE OR SUFFICIENT AREA  
NOT AVAILABLE, ATTACH TAG.

AMS-551BC  
AMS-5519E  
MIL-Q-985B  
NUMBER  
SPEC SUMMARY (REF)

FILE COPY

④ TYPE 303 SST  
2X SIZE

3/4 x 5/8 3/4 x 5/8

1A TYPE AMS 5519E (24 GA) .025

1/8 DIA

25/64

1/8

5/32

1/4

1/2

9 CENT 64 WITHIN .010

1B TYPE AMS 5518C (16 GA) .062

1 WELDMENT

1/8

3/16

1/4

1/2

9 CENT 64 WITHIN .010

1C TYPE AMS 5518C (24 GA) .025

\* TYP

1/4 DIA SLIP FIT FOR DET 4

[illegible]

③ TYPE 303 SST  
2X SIZE

EACH ITEM PURCHASED SEPARATELY  
MUST BE STAMPED OR ETCHED WITH  
TOOL NUMBER AND DETAIL NUMBER.  
IF SUITABLE OR SUFFICIENT AREA  
NOT AVAILABLE, ATTACH TAG.

UOS BREAK SHARP EDGES.020

### SPECIAL INSPECTION AND TEST REQUIREMENTS

WHEN PART OR ASSEMBLY REQUIRES MAGNETIC AND/OR FLUORESCENT PENETRANT INSPECTION, IT MUST BE GOVERNMENT CERTIFIED SPECIAL INSPECTION FACILITY. WHEN PART OR ASSEMBLY REQUIRES WELD, CRACK, FLOW, AND/OR EYE VIEW, IT MUST BE GOVERNMENT CERTIFIED INSPECTION FACILITY. ONLY GOVERNMENT SOURCE INSPECTION MUST HAVE CONFORMANCE APPROVAL OF 8 DAY HEAT TREATING AND COOLING SCHEDULE. INSPECTION MUST BE COMPLETED

ALL PARTS, OTHER THAN EXPERIMENTAL, MANUFACTURED OR PRODUCED TO THIS DRAWING INCLUDING REPLACEMENT PARTS ARE SUBJECT TO QUALITY CONTROL FOR SPECIFICATIONS MIL-Q-9858 AND USASERIES 1000. ALL CHANGES TO THIS DRAWING, INCLUDING REVISIONS AND BULLETINS CONCERNING THE QUALIFICATION, APPROVAL, AND RELIABILITY OF ALLISON PRODUCTS, U3B PROCEDURES MUST INCLUDE PARTICIPATION BY ALLISON ENGINEERING AND QUALITY CONTROL REPRESENTATIVES UNLESS OTHERWISE AUTHORIZED BY ALLISON.

UNLESS OTHERWISE SPECIFIED  
TOL. ON ANGLES =  $\pm 1^\circ$   
TOL. ON 3 PLACE DECIMALS =  $\pm$  FRACTIONS  
TOL. ON 4-PLACE DECIMALS =  $\pm$  FRACTIONS  
4-PLACE DECIMAL DIMENSIONS  
WITHOUT TOLERANCES ARE BASED ON  
MATERIAL *SEE DETS*

HEAT TREAT. _____	
WELD OR BRAZE <i>SEE DETS</i>	
SURFACE TREAT.	INSPECTION

APPROVALS		DATE
DRAWN	M. KING	4-22-6
CHECKED	J. R. P.	4-23-6
C. OF	DR. Fursley	5-3-6
METALLURGY		
ENGR. 1	E. G. W.	4-24-6
ENGR. 2	G. A. L.	4-24-6
ENGR. 3		
FINAL	R. J. H.	4-27-6
REVIEW APPROVAL		

<p align="center"><b>ALLISON DIVISION</b>  <b>GENERAL ELECTRIC CORPORATION</b>  <b>INDIANAPOLIS, INDIANA</b></p>			
<p>TITLE  <i>CLAMP-INSTALLATION, COMPRESSOR SCROLL          TO AIR DUCT (SEAL RING)</i></p>			
<p>MODEL</p>			
<p>CODE</p> <p align="center"><b>73342</b></p>	<p>SIZE</p> <p align="center"><b>C</b></p>	<p>DWG. No.</p> <p align="center"><b>6799953</b></p>	
<p>SCALE <i>FULL</i></p>		<p><i>NOTED</i></p>	<p><i>SHEET 2</i></p>

FILE COPY